

Date: Friday, 15/05/2009 8:58:43 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2893-1
Job Number : 47975	
Estimate Number : 13234	
P.O. Number :	Part Number : DSK078
This Issue : 15/05/2009 S.O. No. :	Drawing Number : DSK078 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 47481	Material :
Written By :	Due Date : 22/05/2009 Qty : 10 Um : Each
Checked & Approved By : <u>JUD 09.05.15</u>	
Comment : est rev A. 08.03.13 new issue EC	
Est Rev:B 09-04-09 Now on Doosan Lathe JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6104005	Round Billet, 17-4
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Support

Batch: B47478

mf 09/05/20

(10)

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE
 Turn blank as per Folio FA081

mf 09/05/20

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 09/05/20

(10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 09/06/08

(10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock in Kanban
 Location: CNE

SA 09/06/08

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DSK 078 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/06/08

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>4775</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.05.19	2	0.020 PART IS 0.020" SHORTER THAN NOMINAL. 0.160" DIM IS 0.077". 0.728 DIM IS 0.740"	CP 09.05.19 PS 05/04/2	OK.	sub 09/05/20	S 09/05/20	CP 09.05.19 PS 05/04/2	S 09/05/20
		QC: operator error Lack of attention						

NOTE: Date & initial all entries

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Drawing Name: TURNING DETAIL FOR D2893-1

Job Number: 47975

Part Number: DSK078

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/08
JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47975
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.710	2.709	2.709	2.710	2.710
B	4.946	4.966		4.956	4.957	4.933	4.957	4.957
C	3.064	3.084		3.076	3.077	3.076	3.076	3.075
D	0.718	0.738		.727	.725	.725/.740	.725	.728
E	0.090	0.110		.101	.101	.100/.088	.100	.101
F	2.934	2.954		2.946	2.946	2.945	2.945	2.945
G	2.166	2.186		2.172	2.172	2.173	2.173	2.175
H	3.890	3.910		3.902	3.902	3.902	3.901	3.901
I	0.914	0.934		.925	.926	.928	.929	.929
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.119	.118	.120	.118	.118
L								
M								
N								
O								
P								

Measured by: *ML* Date: 09/05/19

Audited by: *SA* Date: 09/06/08

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47975
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.710	2.709	2.708	2.709	2.709
B	4.946	4.966		4.958	4.959	4.958	4.959	4.960
C	3.064	3.084		3.076	3.076	3.075	3.075	3.076
D	0.718	0.738		.728	.727	.725	.725	.726
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.934	2.954		2.946	2.945	2.946	2.945	2.946
G	2.166	2.186		2.174	2.175	2.174	2.175	2.177
H	3.890	3.910		3.900	3.901	3.900	3.900	3.900
I	0.914	0.934		.924	.929	.926	.926	.928
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.116	.117	.118	.117	.116
L								
M								
N								
O								
P								

Measured by: *[Signature]* Date: 09/05/20

Audited by: *[Signature]* Date: 09/06/08

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

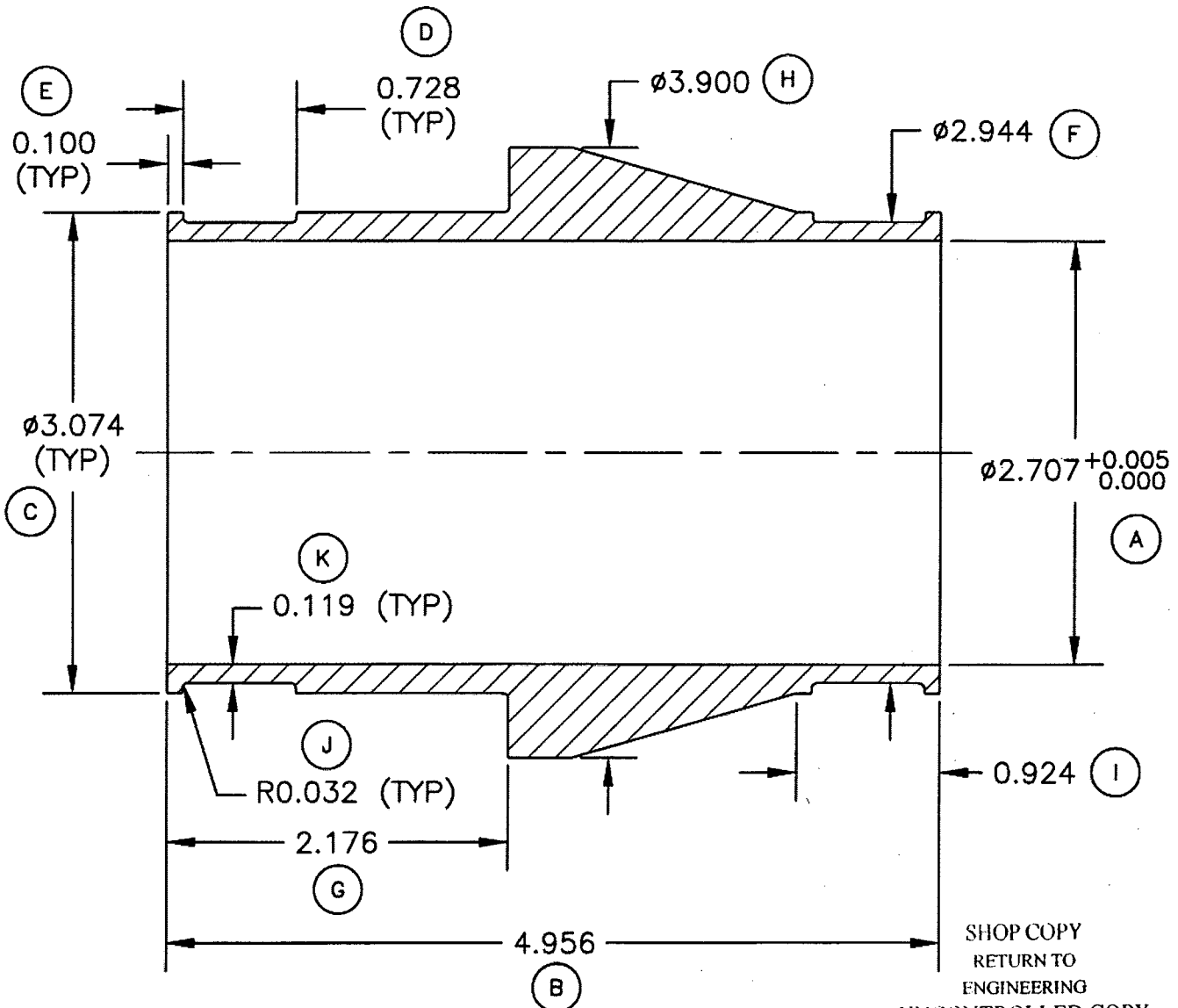
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1 SCALE 1:1	
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



D2893-1 TURNING DETAIL

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